

Date: Thursday, 4/26/2007 3:35:59 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PILOT/CO-PILOT STEP, RH (FOLDING)
Job Number : 32082	
Estimate Number : 10824	
P.O. Number : <i>N/A</i>	Part Number : D412630032
This Issue : 4/26/2007 S.O. No. : <i>N/A</i>	Drawing Number : D412-630 REV <i>K P478-19</i> <i>07.04.19</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NA</i>	Drawing Revision : <i>JK</i>
Previous Run : 28508	Material : <i>N/A</i>
Written By : <i>07.04.26</i>	Due Date : 5/15/2007 Qty: 1 Um: Each
Checked & Approved By : <i>07.04.26</i>	
Comment : EST. REV. A 05.11.21 NEW ISSUE EC	
EST. REV. B 05.12.19 updated pick list EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG001

KS 07.05.07.

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p. *17 18-19*

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

mf 07-07-11

3.0	D3463042	Step Weldment
-----	----------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-042	Step weldment	<i>B29 670</i>

4.0	D3443043	Strut Weldment Assembly
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-043	Strut ass'y	<i>B28529 -</i>

5.0	D3443041	Strut Weldment Assembly
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-041	Strut ass'y	<i>B29671 -</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D34439

PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D3443-9	Pin

Batch

B28/66 -

7.0

AN4CH3

SS Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description
2	AN4CH3	BOLT
A/R	MS20995c41e	Lockwire

Batch

M103248 -
M101537

8.0

AN4C14

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description
1	AN4C14	BOLT

Batch

M103248 -

9.0

D34547

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D3454-7	Bushing

Batch

B30225 -

10.0

AN3104

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description
1	AN310-4	Nut

Batch

M103691

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 32082

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

MS24665227

COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS24665-227 COTTER PIN

M102073 -

12.0

D34551

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3455-1 Spacer

M28171 -

13.0

D34651

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3465-1 Washer

B303080

14.0

AN3107

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN310-7 Nut

M103280 -

15.0

MS24665302

Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS24665-302 COTTER PIN

M16941 -

6/27/11 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

****ensure tension to retract step is 11 to 18 lbs ****

Test fit on aircraft in Eng. lab.

For 107-11

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

18.0

D34541

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3454-1	Bushing

Batch

B28167 ✓

19.0

D34543

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D3454-3	Bushing

Batch

B30223 ✓

20.0

D34545

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D3454-5	Bushing

Batch

B30224 ✓

21.0

D34551

Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description
6	D3455-1	Spacer

Batch

B28171 ✓

EP 5/1/07/110

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Part Number: D412630032

Job Number:



Seq. #:	Machine Or Operation:	Description :
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22.0	D34553	Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3455-3	Spacer	B28172 X

23.0	D3462042	Bracket Assembly
------	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3462-042	Bracket ass'y	B279 B28472 X

24.0	AN3104	NUT
------	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN310-4	Nut	M103641 X ✓

25.0	AN3105	NUT
------	--------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN310-5	Nut	M10276 M102073 X

26.0	AN3C5A	Bolt
------	--------	------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	AN3-C5A	Bolt	M104885 ✓

27.0	AN44C12	eyebolt
------	---------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
			M102198

[Handwritten signature]
4/26/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 32082

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

1

AN44-C12

Eyebolt

28.0

AN4C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN4C15

BOLT

~~B28112~~ M103248 X

29.0

AN5C11

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN5C11

BOLT

M103248 X

30.0

AN5C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN5C15

BOLT

M104395 X

31.0

AN960C10

WASHER



Comment: Qty.: 7.0000 EACH(s)/Unit Total : 7.0000 EACH(s)

Pick:

Qty

Part Number

Description

Batch

7

AN960C10

Washer

M101064 X

32.0

AN960C516

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN960C516

Washer

M17697 X

[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 32082

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

MS210433

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description
3	MS21043-3	Nut

Batch

M104679 ✓

34.0

MS24665227

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description
2	MS24665-227	COTTER PIN

Batch

M102073 ✓

35.0

MS24665229

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description
2	MS24665-229	COTTER PIN

Batch

M19096 ✓

36.0

NAS1515H5

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description
1	NAS1515H5	Washer

Batch

M104679 ✓ 2/27/11 ✓

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

2/27/11 ✓ 2/27/11 ✓

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-031

Location:

PPP Rev:

A 2/27/11 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/07/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 32082

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

2007/11

Job Completion



u 070711

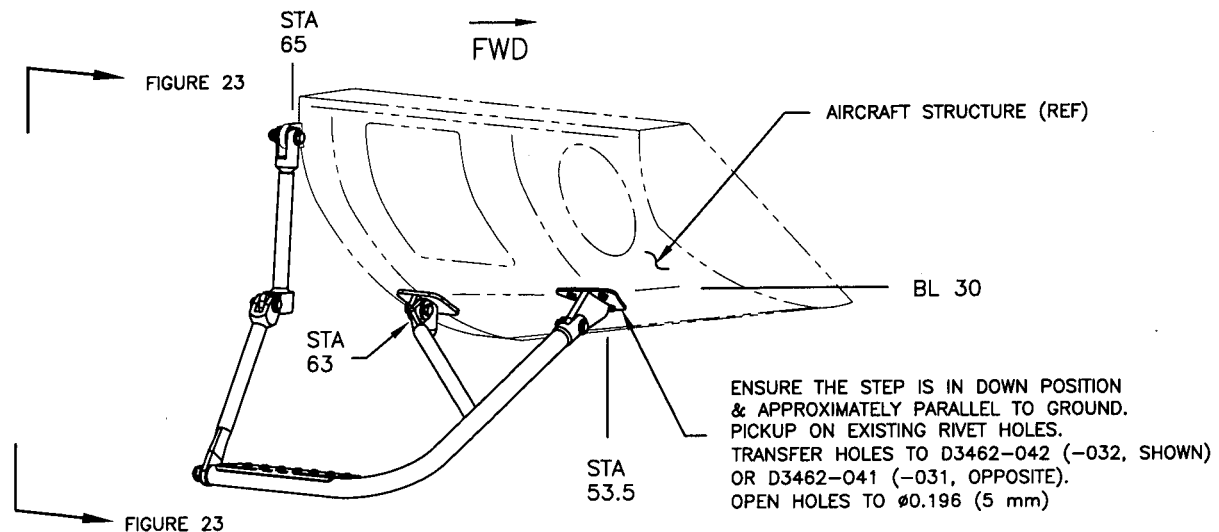
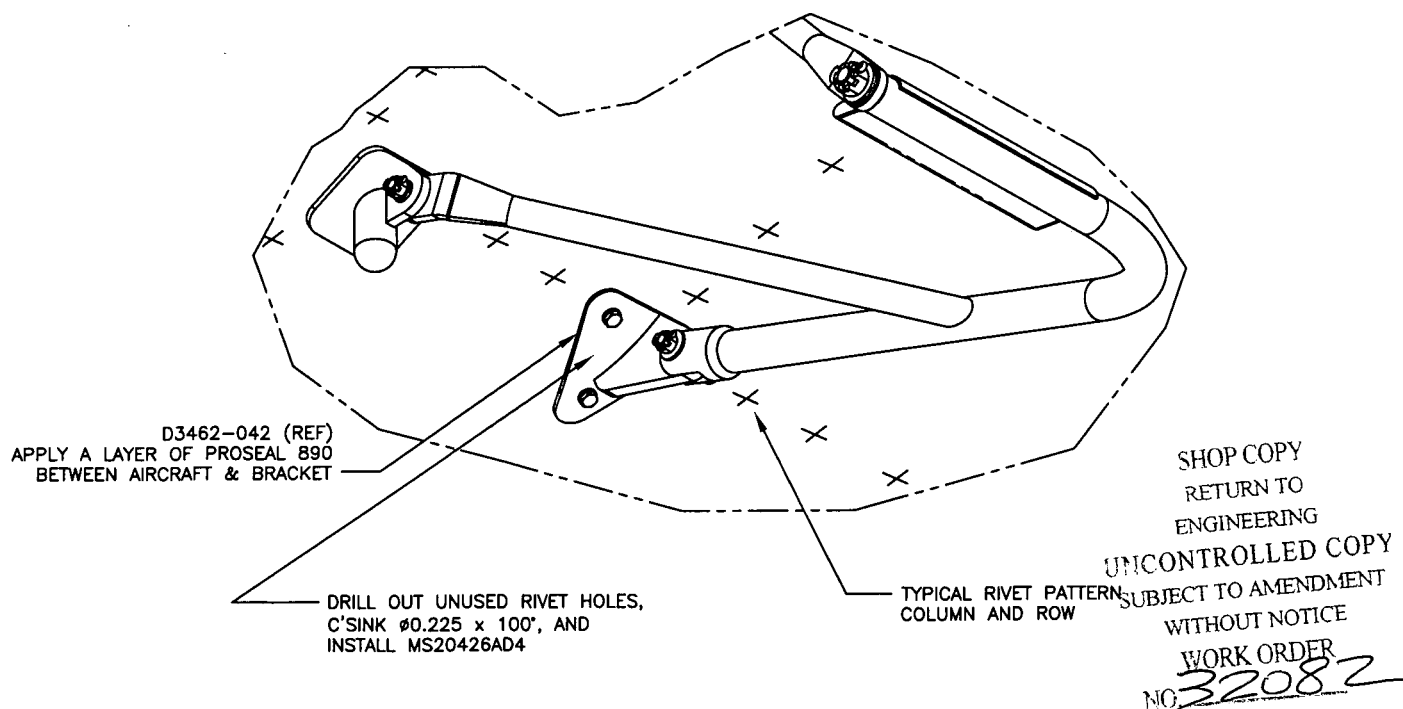
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D412-630-031/-032 Pilot/Co-Pilot Folding-Step Installation**FIGURE 21 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown),
D412-630-031 LH (Opposite)****FIGURE 22 – Detail View D3462-042 Bracket Assembly (-032 Installation, Shown)
D3462-041, (-031 Installation Opposite)**

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Revision: **K**
Date: 06.10.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

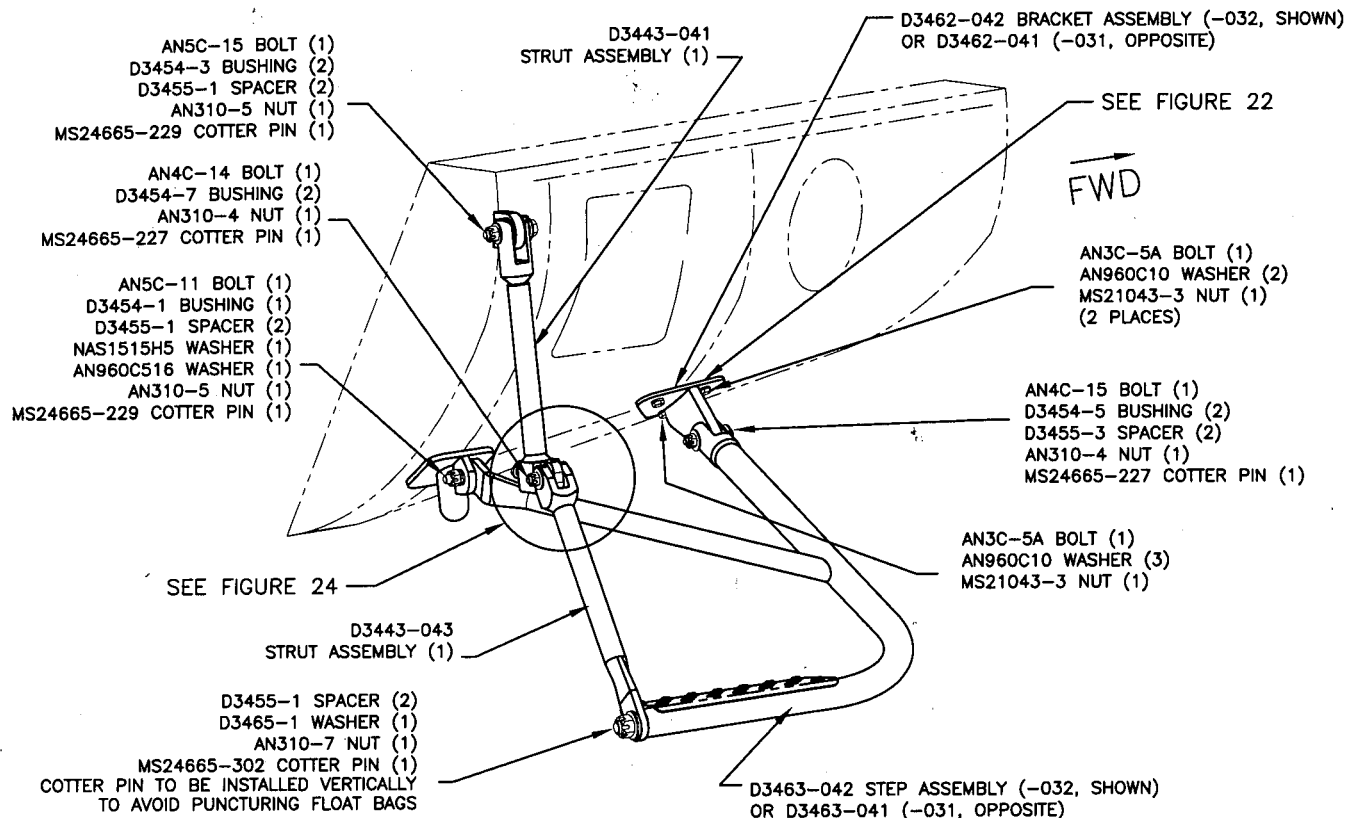
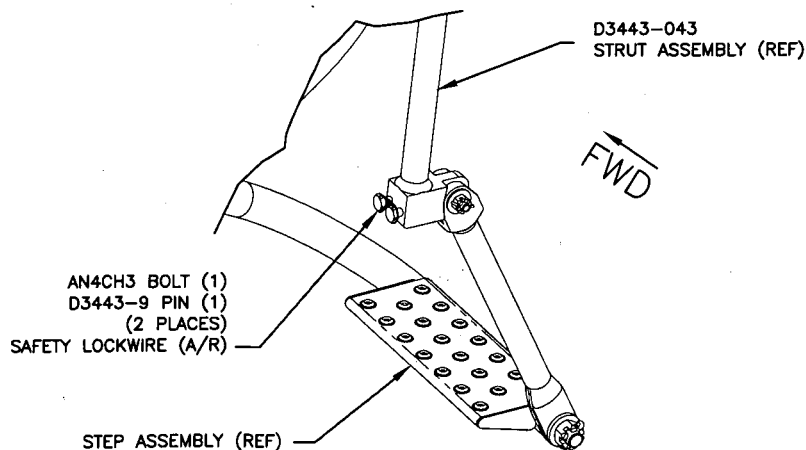


FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32082

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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